

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009008**Date Inspected:** 06-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M. Manikandan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (1AE)

FCAW Process:

Welding of weld joint -153 located on PCMK SSD34A-PP8.5. Welder is identified as 050316

ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-Tc-U4b-FCM.

OBG # TRIAL ASSEMBLY YARD (5BE)

FCAW Process:

Welding of weld joint -043 and 054 located on PCMK SP359A-001. Welder is identified as 220077

ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

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OBG # TRIAL ASSEMBLY YARD (5BE)

SMAW Process:

Welding of weld joint –013 and 017 located on PCMK DP633A-001. Welder is identified as 068764
ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the
WPS-B-F-2114-FCM-1.

OBG # TRIAL ASSEMBLY YARD (5CE)

FCAW Process:

Welding of weld joint –011 and 020 located on PCMK SP425A-001. Welder is identified as 220077
ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the
WPS-B-T-2132.

OBG # TRIAL ASSEMBLY YARD (5CE)

SMAW Process:

Welding of weld joint –007 and 012 located on PCMK DP634A-001. Welder is identified as 068764
ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the
WPS-B-F-2114-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
